

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020091**Date Inspected:** 22-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

SMAW welding of critical repair (R5) weld is identified as 2G-005 of SB023-106 for SB106 East. The welder is identified as 066418. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2G-Repair and CWR-2747.

SMAW welding of critical repair (R5) weld is identified as 2G-002 of SB023-106 for SB106 West. The welder is identified as 066418. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2G-Repair and CWR-2727.

SMAW welding of critical repair (R4) weld is identified as 3G-002 of SB022-106 for SB106 West. The welder is identified as 037997. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-3G-Repair and CWR-2747.

FCAW welding of weld is identified as 3F-006 of SB024-108 for SB108 West. The welder is identified as 062808. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2133-ESAB.

ABF QC NDT MT personnel performing MT on arc gouged CWR location prior to critical repair work of SB106

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West in progress.

ABF QC NDT MT personnel performing MT on sole plate filler welds in progress of BK004A-014.

This QA inspector performed VT internal welds and cleanliness checked the locations where need additional grinding and cleaning marked. ZPMC personnel repaired those locations. The bike path is identified as BK005A-002.

ZPMC personnel performing drilling of bolt holes in Suspender bracket bottom bearing plate (X67) is in progress the suspender bracket is identified as SB104 East for Lift-11.

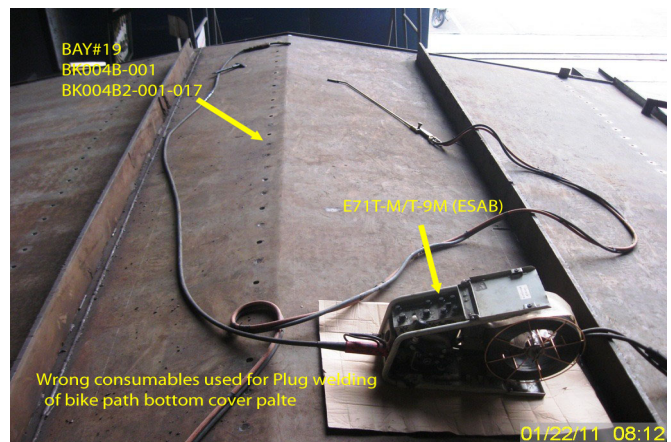
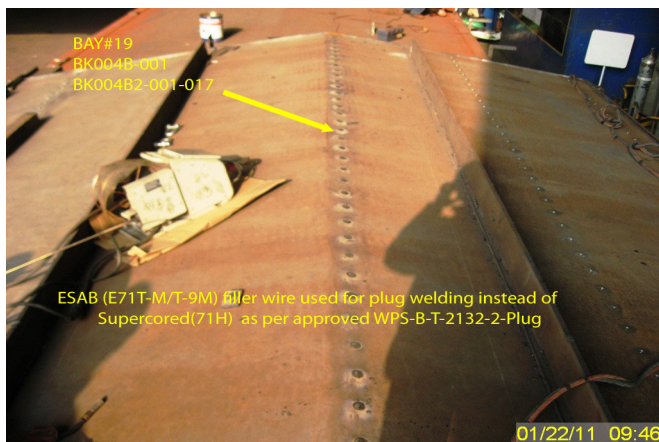
During random in-process inspection of the plug weld on OBG Bike path, Caltrans Quality Assurance (QA) Inspector discovered the following issue;

- ZPMC personnel were using different FCAW electrode brand then specified in approved WPS.
- According to the approved FCAW Plug weld WPS the FCAW electrode brand is Hyundai Super Cord (E71H).
- ZPMC personnel was using ESAB FCAW (E71T-M/T-9M) electrode.
- The bike path is identified as; BK004B-001.

For more information please see the Incident report

Incident_Report_TL-15_B247_01-22-11_BK004B-001_Wrong_Consumable_used.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer